

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013378**Date Inspected:** 11-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Liu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062772 perform Shielded Metal Arc Welding (SMAW) Welding on suspender bracket, weld joint identified as SB008-046-009. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F)-Repair, which is used as per Critical Welding Repair Report (CWR) B-CWR1246.

This QA inspector observed ZPMC qualified welding personnel identified as 062772 perform Shielded Metal Arc Welding (SMAW) Welding on Bike Path; plates are identified as BKPL1A and BKPL2A. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-1G (1F)-Repair, which is used as per Welding Repair Report (WRR) B-WR10881. See the attached pictures.

This QA observed ZPMC personnel performing MT on suspender bracket and bike path base metal repair area. The suspender bracket is identified as SB008-040E and bike path plates are identified as BKPL1A and BKPL2A.

Ultrasonic Testing (UT) - Document: 005316

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. SB008-040-031, 043, 011, 055

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 050242 perform Flux Cored Arc Welding (FCAW) Welding on OBG Segment 11DE, weld joint identified as SEG072*-009. ZPMC QC is identified as Mr. Zhong Guo hai.. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-B-U2-F.

This QA inspector observed ZPMC qualified welding personnel identified as 044772 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 11DE, weld joint identified as SEG072*-045. ZPMC QC is identified as Mr. Zhong Guo hai. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 201087 perform SMAW Welding on OBG Segment 11DE, weld joint identified as SEG072*-040 and 024. ZPMC QC is identified as Mr. Zhong Guo hai. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2213-B-U2-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 200113 perform SMAW Welding on OBG Segment 11DE, weld joint identified as SEG072*-010. ZPMC QC is identified as Mr. Zhong Guo hai. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1.

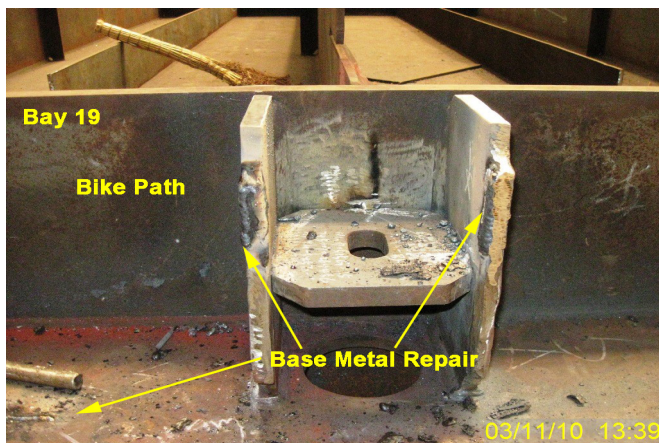
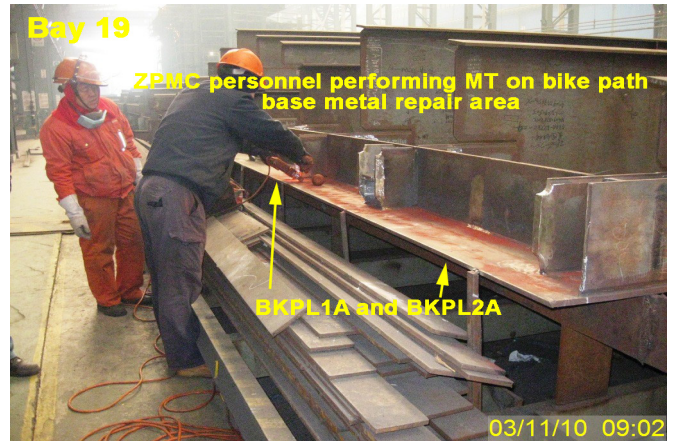
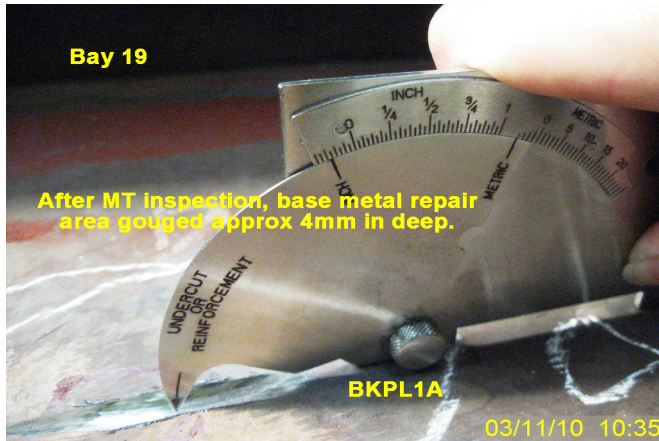
This QA inspector observed ZPMC qualified welding personnel identified as 201087 perform FCAW Welding on OBG Segment 11DE, weld joint identified as SSD16-PP104-131~137. ZPMC QC is identified as Mr. Zhong Guo hai. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2114-FCM.

This QA inspector observed ZPMC qualified welding personnel identified as 201087 perform FCAW Welding on OBG Segment 11DE, weld joint identified as SSD17-PP105-004. ZPMC QC is identified as Mr. Zhong Guo hai. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2213-B-U2-FCM-1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer